

010530



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

15195

D4039-041**Job Sheet 193121****Part No:** D4039-041**Job Qty:** 1 pcs**Part Name:** Fwd Bracket Assembly**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/9/19**Job Tracking No:** 15195**Due Date:** 5/13/19**Created By:** Dara Macdonald**Type:** SOLD**Description:**

Note: DWG D4039 REV D IPP RevA: new issue DD 09.12.15 verified by:EC IPP REV B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV. C AS PER ECN 18-592 18/05/07 JFS VERIFIED BY:DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	5/13/19		0.00	0.75	Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	5/13/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
120	Packaging 3-1 - Stock - B4B	1 pcs	5/13/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

**Container No:** S193520**Part:** D4039 - 041**Job No:** 193121**Serial No/Batch:** S193520**Revision:** D**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 06/25/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - SA	1 pcs	5/13/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21 JUL 05 2019

Part Op 100 - (Small Fab) 1- Install bushing as per dwg. (Note 8). After bushing as warm up to room temperature, verify 0.257"
 Descriptions: hole in bushing. Ream if required. 2- Assemble lanyard to bracket as per dwg.

110 - (QC5- Inspect part completeness to step on W/O)

120 - (Identify as per dwg & Stock Location: _____)

130 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2690-6	Lanyard	ST009 1 pcs (1 ea)	100-Small Fab - 1	5187688
D4039-1	Fwd Bracket	ST477 1 pcs (1 ea)	100-Small Fab - 1	8137589
D5626-1	Bushing	ST178 2 pcs (2 ea)	100-Small Fab - 1	5175583
MS17984-C416	Quick Release Pin	over ccs 1 Ea (1 ea)	100-Small Fab - 1	5131699
MS21042L3	Nut	ST803 1 Ea (1 ea)	100-Small Fab - 1	5140299
MS27039-1-11	Screw	ST240 1 Ea (1 ea)	100-Small Fab - 1	FT138326.82
NAS1149D0363J	Washer	ST262 3 Ea (3 ea)	100-Small Fab - 1	5176545

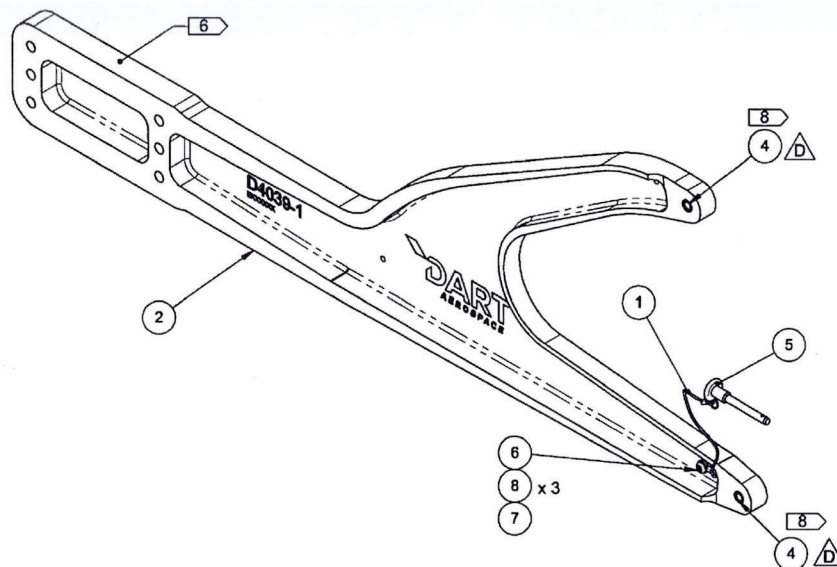
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2690-6	1	42	0
	D4039-1	1	3	0
	D5626-1	2	0	0
	MS17984-C416	1	6	0
	MS21042L3	1	3,710	0
	MS27039-1-11	1	221	0
	NAS1149D0363J	3	1,458	0

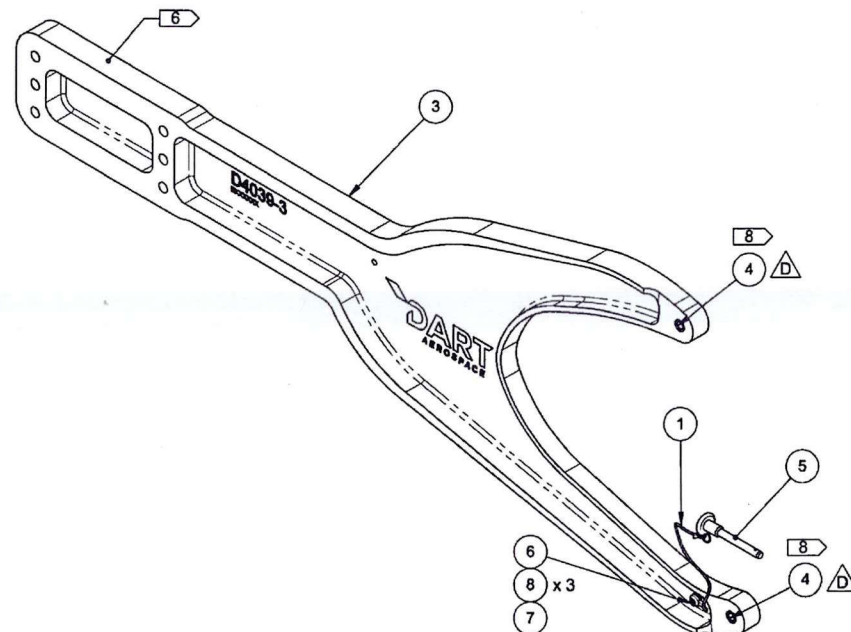
Part Specifications
Specifications could not be found.

Plex 4/9/19 9:09 AM Dart.Macdonald.Dara

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4039-041	FWD BRACKET ASSEMBLY
		X	D4039-043	AFT BRACKET ASSEMBLY
1	1	1	D2690-6	LANYARD
2	1		D4039-1	FWD BRACKET
3		1	D4039-3	AFT BRACKET
4	2	2	D5626-1	BUSHING
5	1	1	MS17984-C416	PIN, QUICK RELEASE
6	1	1	MS27039-1-11	SCREW, PAN-HEAD
7	1	1	MS21042L3	NUT, SELF-LOCKING
8	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: N/A
- 8) COOL/FREEZE THE D5626-1 BUSHINGS. INSTALL THE BUSHINGS IN THE DRILLED/REAMED HOLES. THE BUSHINGS ARE DESIGNED WITH AN INTERFERENCE FIT SO PRESSING MAY BE REQUIRED. ALLOW THE D5626-1 BUSHINGS TO WARM UP IN THE MOUNTING HOLES. MAKE SURE THE BUSHINGS REMAIN CENTERED AND PRESSED INTO PART. VERIFY ID OF BUSHINGS AFTER INSTALLATION IS $\phi 0.257$, REAM AS REQUIRED.

RELEASED

2018 MAY 03
ECN 18-592

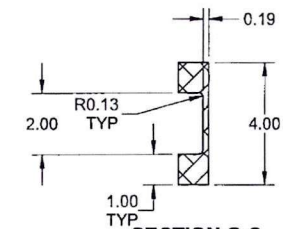
D	ADDED D5626-1 TO -041 & -043 ; ADDED NOTE 8 TO SHEET 1 & NOTE 11 TO SHEETS 2 & 3; $\phi 0.4375$ WAS $\phi 0.261$; REF CAR17-189	RF	18.03.05
C	REVISE DESIGN OF -1 AND -3 BRACKETS; ZN C4-2, B4-2, C4-3, B4-3, REVISE NOTES 7 AND 8; A8-2, A8-3, B5-1	VS	15.11.05
B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B6-3	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	RF		
CHECKED	WK		
MFG. APPR.	RQ		
APPROVED	DSW		
DE APPR.	DS		
DATE	18.03.05		

APPROVED

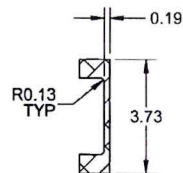
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. D
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

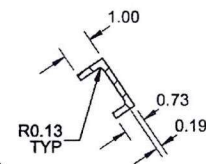
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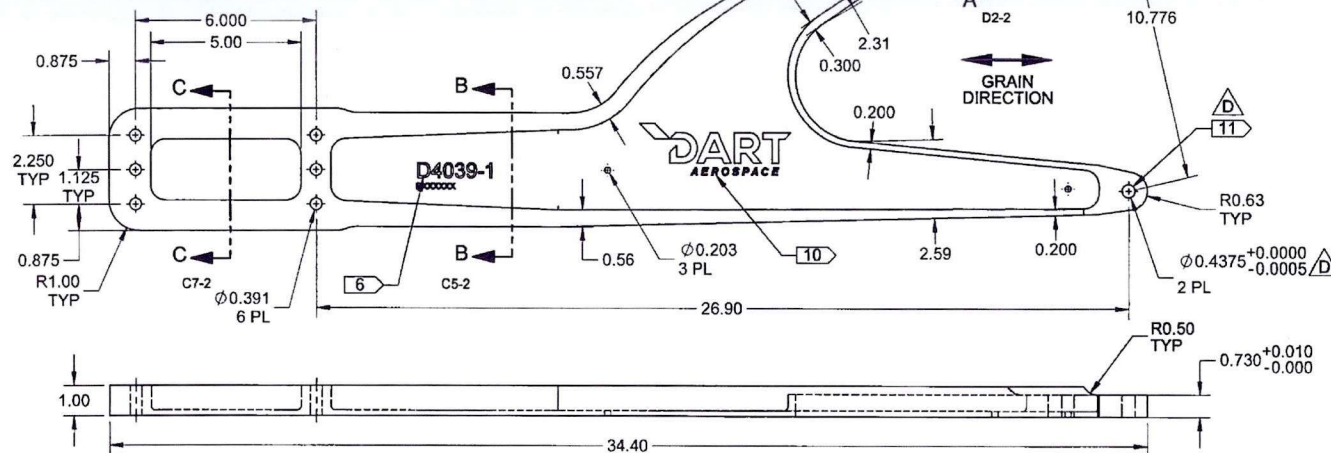
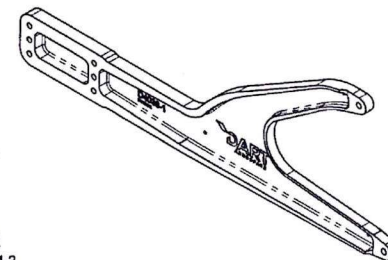
SECTION C-C
B7-2



SECTION B-B
B6-2



SECTION A-A
C4-2



D4039-1 FWD BRACKET

NOTES:

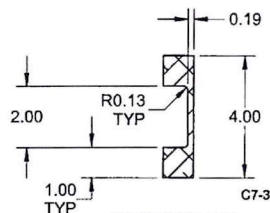
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
- 7) WEIGHT: 6.59 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. D
- 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. D
- 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250
- 11) MASK HOLES PRIOR TO POWDER COAT

RELEASED

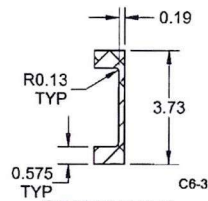
2018 MAY 03

APPROVED

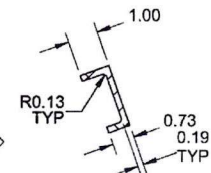
DESIGN	VS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WK	DRAWING NO.	REV. D
MFG. APPR.	RQ	D4039	SHEET 2 OF 3
APPROVED	DSW	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	18.03.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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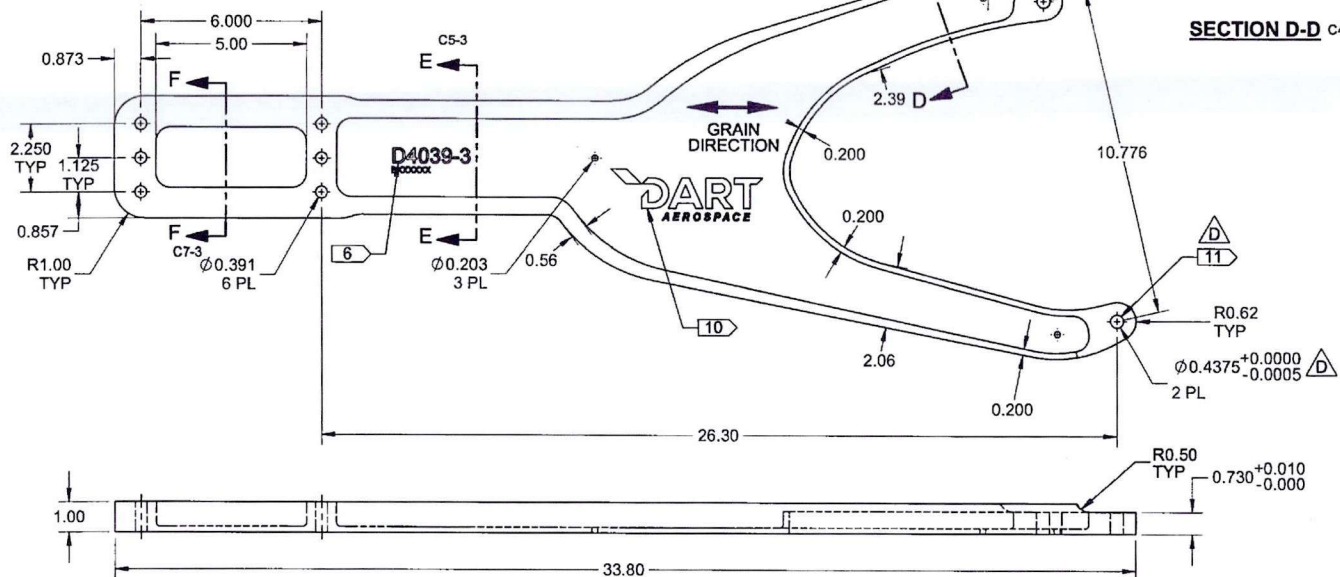
SECTION F-F



SECTION E-E



SECTION D-D



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
- 7) WEIGHT: 6.39 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3.SLDPRT" AT REV. D
- 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-3.SLDPRT" AT REV. D
- 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250
- 11) MASK HOLES PRIOR TO POWDER COAT

D4039-3 AFT BRACKET

RELEASED

2018 MAY 03

APPROVED

DESIGN	VS
DRAWN	RF
CHECKED	WK
MFG. APPR.	RQ
APPROVED	DSW
DE APPR.	DS
DATE	18.03.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. D
TITLE **BRACKET** SCALE NTS

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